

FIG.1A

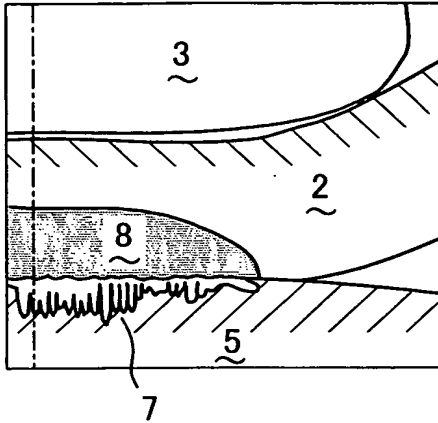


FIG.1B

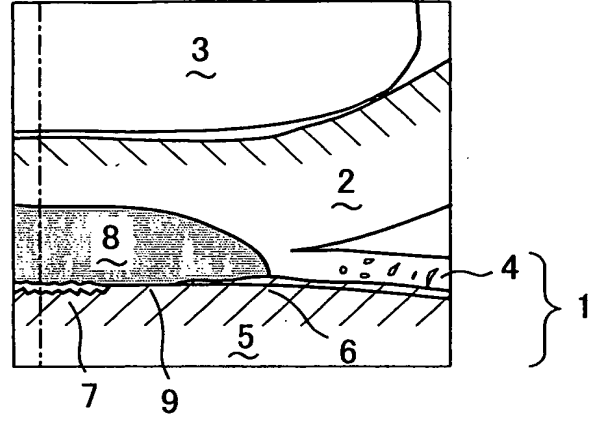


FIG.2

weld cycle time	peripheries of nuggets	centers of nuggets
1	<p>Si:3.1%, Fe:35.6%</p>	<p>Si:1.7%, Fe:37.6%</p>
3		<p>Si:0.9%, Fe:40.8%</p>
6		<p>Si:0.8%, Fe:46.0%</p>

1 μ m

FIG.3

